

633.013

Dart Aerospace Ltd.

Date: Wednesday, 29/04/2009 3:01:05 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STEP WELDMENT	
<b>Job Number</b> :	47597A			
<b>Estimate Number</b> :	10176			
<b>P.O. Number</b> :		<b>Part Number</b> :	D2563	
<b>This Issue</b> :	29/04/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2563 REV C	
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	47412A	<b>Drawing Revision</b> :	C	
<b>Written By</b> :		<b>Material</b> :		
<b>Checked &amp; Approved By</b> :	JUD 09.04.29	<b>Due Date</b> :	05/05/2009	<b>Qty:</b> 4 <b>Um:</b> Each
<b>Comment</b> :	Est Rev:G 02.07.31 Re-format Location RF			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
✓ 1.0	D2244116	Step Extrusion								
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: 1 D2244 Step Extrusion Batch: 33733 (3) 38023 (1) SAD 09-05-06 (4)										
2.0	D267334	End Plate								
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: <table border="0"> <tr> <td>Qty</td> <td>Part No.</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>D2673-34</td> <td>End Cap</td> <td>335887</td> </tr> </table>			Qty	Part No.	Description	Batch	2	D2673-34	End Cap	335887
Qty	Part No.	Description	Batch							
2	D2673-34	End Cap	335887							
3.0	D2561	Lug								
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: <table border="0"> <tr> <td>Qty</td> <td>Part No.</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>D2561</td> <td>Lug Plate</td> <td>340935</td> </tr> </table>			Qty	Part No.	Description	Batch	2	D2561	Lug Plate	340935
Qty	Part No.	Description	Batch							
2	D2561	Lug Plate	340935							
4.0	D2564	Mounting Angle								
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: <table border="0"> <tr> <td>Qty</td> <td>Part No.</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>D2564</td> <td>Mounting Angle</td> <td>340936</td> </tr> </table>			Qty	Part No.	Description	Batch	2	D2564	Mounting Angle	340936
Qty	Part No.	Description	Batch							
2	D2564	Mounting Angle	340936							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:01:05 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 47597A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

SAD 09-05-06 (4)

2-Deburr ends

SAD 09-05-06 (4)

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

A/R AL ROD Batch: M110972  
M110130

*PE* 09-05-08 4

4- Grind

SAD 09-05-08

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*BE* 09-05-11 (4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*809/05/11* (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 09-05-11 (4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PE* 09-05-12 4

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remainig End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M110130

3-Grind

*PE* 09-05-12 4

*PE* 09-05-12 4

SAD 09-05-12 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:01:05 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 47597A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-05-13 (Y)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/13 (X4)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

14:00  
320°  
14:30

UMO

09/05/14

(X4)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

1111013

09-05-19 X4

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/20 (Y)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/21 (X4)

Job Completion



MF 09-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

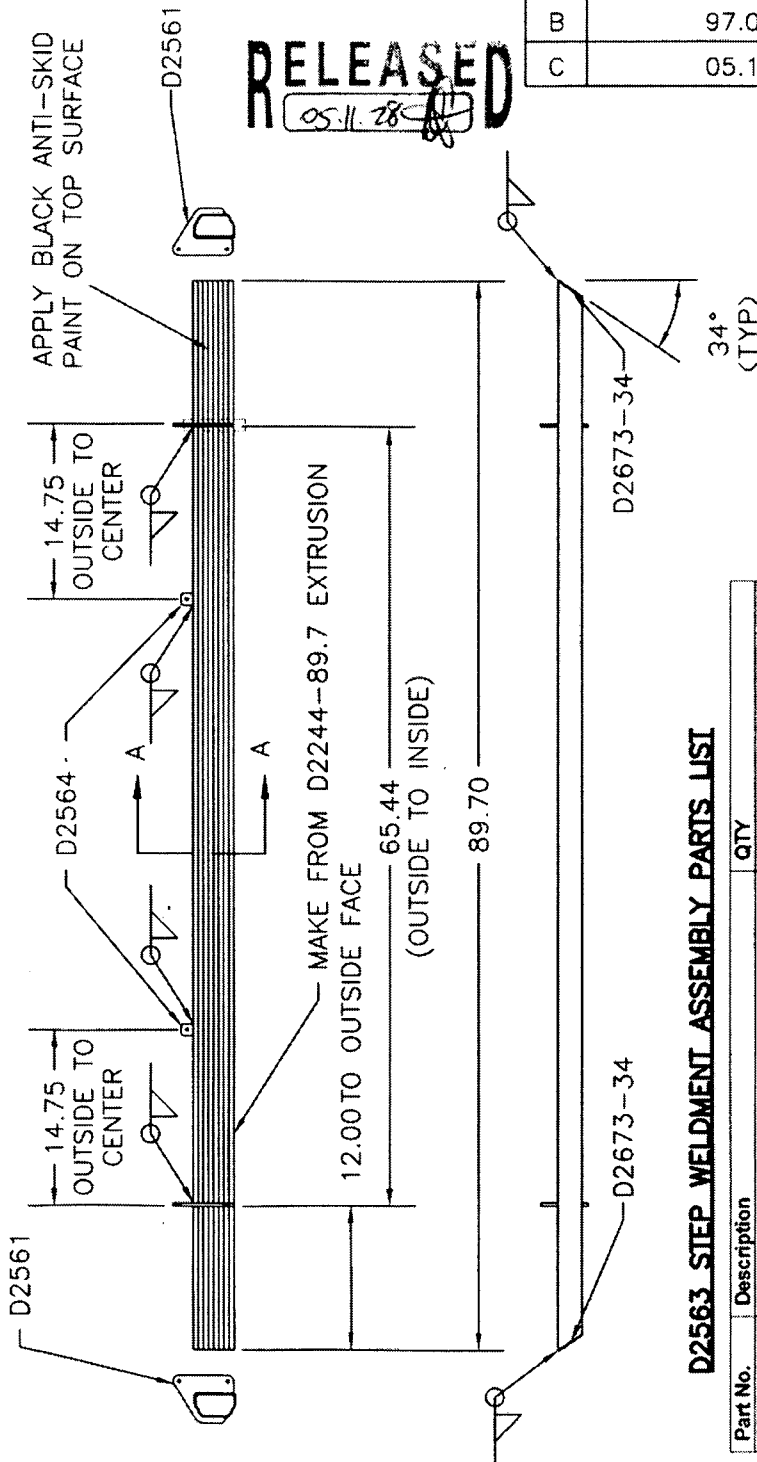
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2563	REV. C SHEET 1 OF 1
DATE 05.11.14	TITLE STEP WELDMENT ASSEMBLY		SCALE 1:15
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	

**RELEASED**  
05.11.28**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
NOT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
4-159774

**D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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